

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0

REF. TCCA STC SH08-53

REF. FAA STC SR02692NY

REF. EASA STC EASA.IM.R.S.01529

It has come to Dart's attention that due to variances in airframe, the D3608-1/-3 Lower/Upper Doublers of the D412-775-013 Step Protective Trim Kit at CHG 001 may not always fit as intended. To ensure proper fit, Dart has made changes to both D3608-1/-3 Doublers at CHG 002 and later.
The manuals listed above are amended as follows:

IS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\phi 0.141"$) holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\phi 0.141"$) holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

WAS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\phi 0.141"$) holes from the aircraft to the D3608-1/-3 Doublers.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

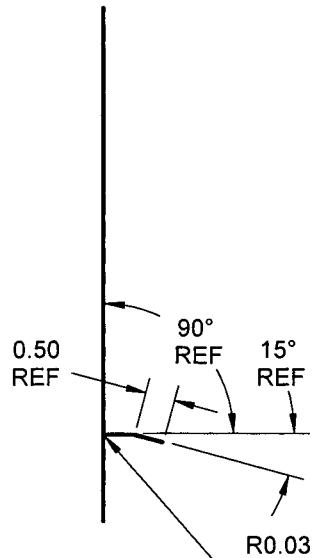
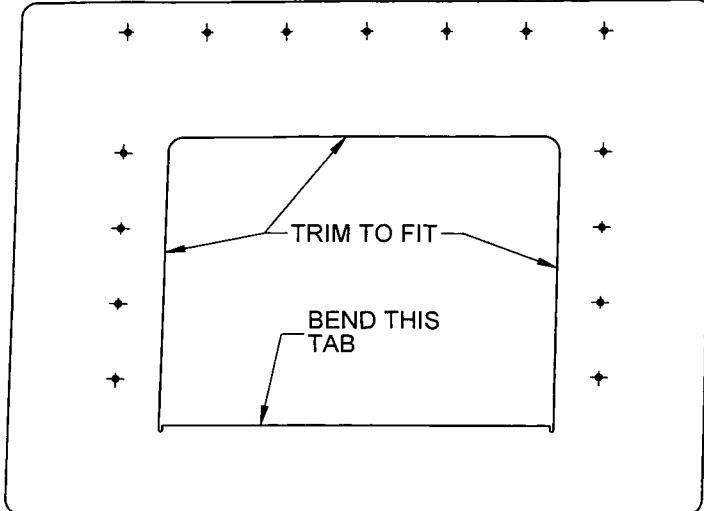
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\phi 0.141"$) holes from the aircraft to the D3608-1/-3 Doublers.

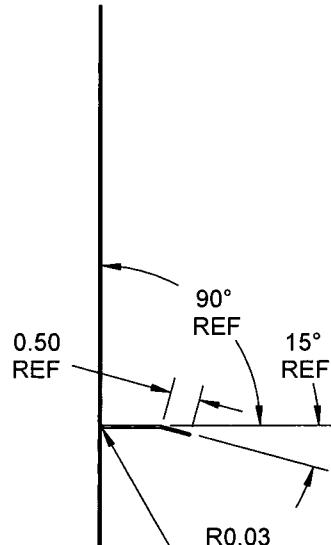
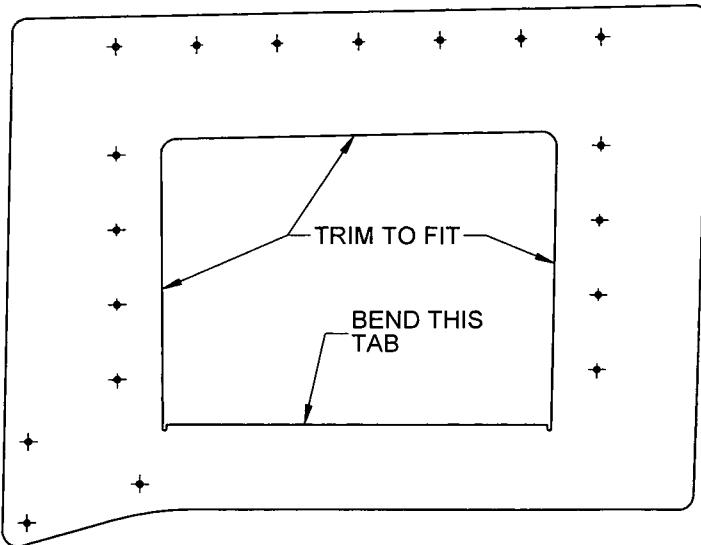
NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	10.02.05
CERT. NO.:	SH08-53
ISSUE NO.:	1

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REV.	DESCRIPTION	BY	DATE
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CHECKED			
MFG. APPR.	N/A		
APPROVED		DRAWING NO.	REV. A
DE APPR.		DSI 9503	SHEET 1 OF 2
DATE	10.02.05	TITLE	SCALE
		STEP PROTECTIVE TRIM CHG NTS	
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D3608-3 BENT UPPER DOUBLER



D3608-1 BENT LOWER DOUBLER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 10.02.05
CERT. NO.: SH08-53
ISSUE NO.: 1

FIGURE 1: TRIMMING/BENDING OF D3608-1/-3 DOUBLERS
(PARTS SHOWN PRIOR TO TRANSFER DRILLING)

DESIGN	<i>1</i>
DRAWN	<i>1</i>
CHECKED	<i>Q</i>
MFG. APPR.	N/A
APPROVED	<i>10</i>
DE APPR.	<i>10</i>
DATE	10.02.05

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